

# Work Order ID 52466

Friday, September 25, 2009 10:02:19 AM

Page 1

Item ID: D3199-1 **GY** Accept

Revision ID: B

Item Name: Bracket

Start Date: 9/25/2009 Start Qty: 72.00

Required Date: 10/6/2009 Req'd Qty: 72.00

Reference:

Approvals: Process Plan: PL Date 09-25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

|       |       |
|-------|-------|
| D3199 | Rev B |
|-------|-------|

100 0.00



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

Cut as per Dwg D3199 ☒ Dwg Rev: B ☐ Prog  
Rev: B ☐ Deburr if required

IB 9-10-8

86

110 0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

IB 9-10-8

120 0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

2) 8/21/08

Control  
486

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|                |           |            |       |       |               |  |
|----------------|-----------|------------|-------|-------|---------------|--|
| Item ID:       | D3199-1   | Accept     |       | Setup | Start         |  |
| Revision ID:   | B         |            |       |       | Stop          |  |
| Item Name:     | Bracket   |            |       |       |               |  |
| Start Date:    | 9/25/2009 | Start Qty: | 72.00 |       | Cust Item ID: |  |
| Required Date: | 10/6/2009 | Req'd Qty: | 72.00 |       | Customer:     |  |
| Reference:     |           |            |       |       |               |  |

|            |               |       |            |       |     |       |  |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling:   | Date: | Run | Start |  |
|            | QC:           | Date: | SPC (Y/N): | Date: |     | Stop  |  |

| Sequence ID/<br>Work Center ID | Operation<br>Description                      | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130<br>                        | Small Fab                                     | 0.00                 |                |              |              |               |               |                  |                |
| Small Fab                      | Memo  | 0.00                 |                |              |              | 86            | 0             |                  |                |
| Small Fab                      | Form as per dwg D3199                         |                      |                |              |              |               |               |                  |                |
| 140<br>                        | QC5- Inspect part completeness to step on W/O | 0.00                 |                |              |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control                |   |                      |                |              |              |               |               |                  |                |
| 150<br>                        | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3      | 0.00                 |                |              |              |               |               |                  |                |
| Powdercoat                     | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| Powder Coating                 | START TIME: 8:20am                            |                      |                |              |              |               |               |                  |                |
|                                | 8:50am  |                      |                |              |              |               |               |                  |                |
|                                | FINISH TIME: 3:20pm                           |                      |                |              |              |               |               |                  |                |

SD 09/10/14

SD 09/10/14

SD 09/10/15

count  
(86) 4

(86) 4

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Item ID: D3199-1

Accept

Revision ID: B

Item Name: Bracket

Start Date: 9/25/2009 Start Qty: 72.00

Required Date: 10/6/2009 Req'd Qty: 72.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BK 09-10-15

(56)

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_ 0.00

Memo

0.00

09/10/15 (86)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

09/10/16  
BA 09-10-15

# Picklist Print

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Friday, September 25, 2009 10:02:19 AM

Work Order ID: 52466

Parent Item: D3199-1RevB

Parent Item Name: Bracket



Comments:

Start Date: 9/25/2009

Required Date: 10/6/2009

Start Qty: 72.00

Required Qty: 72.00

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick  | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| M304S20GA<br> |                        | Purchased     | No          |                     |                  | 100             | sf                 | 203.1708       | 7.5032  | 9.000         |                |        |
| 304/316 .040 Sheet  |                        |               |             |                     |                  |                 |                    |                |  |               |                |        |

18 9-10-8

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

203.1708474

110076

31.73

111571

22.1340474

112567

149.3068

110076 X70

112567 X16

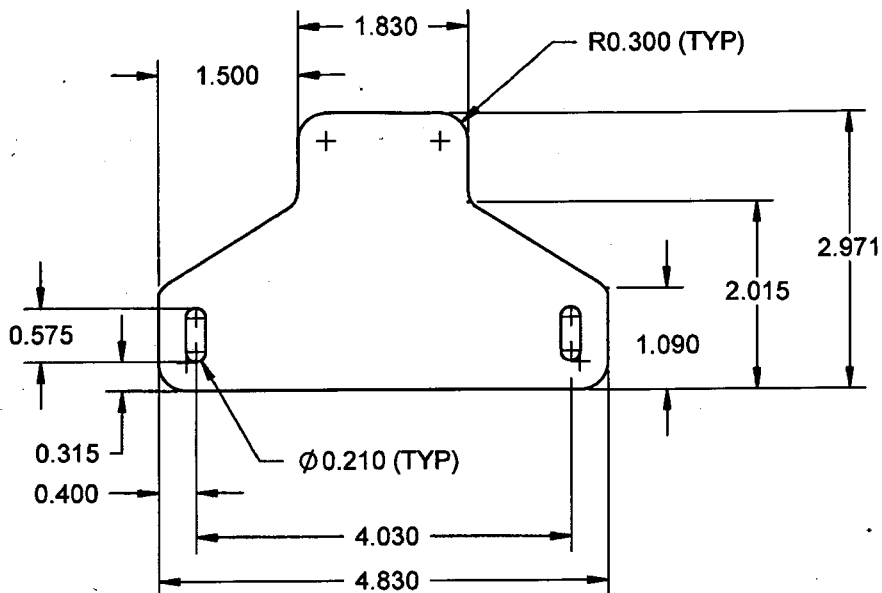
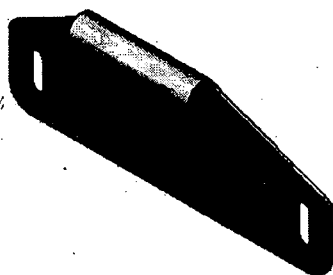




| DESIGN<br><i>CP</i>     | DRAWN BY<br><i>CB</i>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
|-------------------------|--------------------------------|--|------------------------|
| CHECKED<br><i>LE</i>    | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3199</b>                              | REV. B<br>SHEET 1 OF 1 |
| DATE<br><b>06.11.01</b> | TITLE<br><b>BRACKET</b>        |  | SCALE<br>1:2           |
| REV                     | DATE                           | DESCRIPTION  |                        |
| A                       | 03.08.05                       | NEW ISSUE  |                        |
| B                       | 06.11.01                       | 2.24 WAS 2.142; ADD FINISH; UPDATE DWG                   |                        |

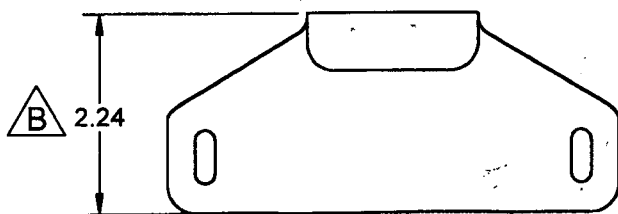
**RELEASED**

*06.11.20* *[Signature]*

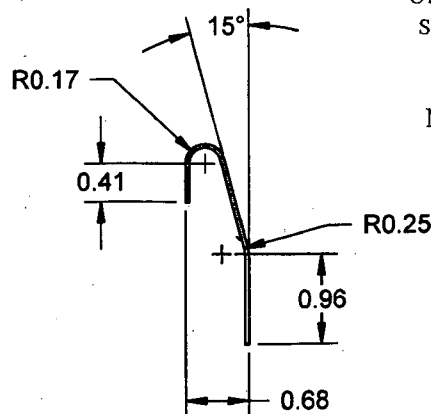


**D3199-1 FLAT PATTERN**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *524166*



**D3199-1 BRACKET**



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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